



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5377-1
Job Sheet 171593



Part No: D5377-1

Job Qty: 8 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 2/5/18

Job Tracking No:

Due Date: 2/18/18

Created By: Jason Leroux

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 16-01-08 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		2/16/18	0.00	0.00	Start Up Waterjet		on 18/02/18
120	Waterjet	8 pcs		2/16/18	0.00	4.65	Waterjet1		on 18/02/18
130	CNC Vertical Machining	8 pcs		2/18/18	0.62	20.51	HAAS1-2		on 18/02/18
140	QC	8 pcs		2/18/18	0.00	0.00	QC2 Machining-4		on 18/02/18
150	QC	8 pcs		2/18/18	0.00	0.00	QC8 Machining-4		on 18/02/18
151	Packaging	8 pcs		2/18/18	0.00	0.00	Packaging3		on 18/02/18
190	QC21-SA	8 Ea		2/18/18	0.00	0.00	QC21		on 18/02/18

Part Op 120 - Cut Blank as per D5377-1_blank File

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per FolioFB448 and Dwg

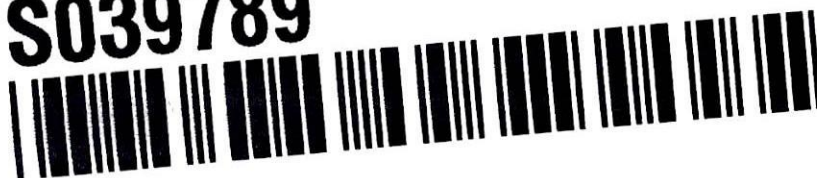
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	42.4000 sf (5.3 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MUHMWB10	42	712	0

DART
AEROSPACE
S039789



Bearpaw

PART NO: D5377 - 1
Original Serial #: S039789
Revision:
Operation:
Change No:

Start up Operation 02/07/18

Job No: 171593

Dart Aerospace Ltd.
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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.380Inches ± 0.030	0.410 0.350		
2	Bearpaw	5.000Inches ± 0.030	5.030 4.970		
3	Bearpaw	3.930Inches ± 0.030	3.960 3.900		
4	Bearpaw	1.380Inches ± 0.030	1.410 1.350		
5	Bearpaw	5.500Inches ± 0.030	5.530 5.470		
6	Bearpaw	1.720Inches ± 0.030	1.750 1.690		
7	Bearpaw	2.0Degrees ± 0.0	2.0 2.0		
8	Bearpaw	15.440Inches ± 0.030	15.470 15.410		
9	Bearpaw	4.688Inches ± 0.010	4.698 4.678		
10	Bearpaw	0.756Inches ± 0.010	0.766 0.746		
11	Bearpaw	0.700Inches ± 0.010	0.710 0.690		
12	Bearpaw	24.000Inches ± 0.030	24.030 23.970		
13	Bearpaw	21.340Inches ± 0.030	21.370 21.310		
14	Bearpaw	6.400Inches ± 0.030	6.430 6.370		
15	Bearpaw	3.520Inches ± 0.030	3.550 3.490		
16	Bearpaw	0.240Inches ± 0.030	0.270 0.210		
17	Bearpaw	0.250Inches ± 0.010	0.260 0.240	Radius	
18	Bearpaw	0.300Inches ± 0.030	0.330 0.270		
19	Bearpaw	45.0Degrees ± 0.5	45.5 44.5		
20	Bearpaw	0.500Inches ± 0.030	0.530 0.470		
21	Bearpaw	0.740Inches ± 0.030	0.770 0.710		
22	Bearpaw	0.950Inches ± 0.030	0.980 0.920		
23	Bearpaw	0.261Inches + 0.006 - 0.001	0.267 0.260		
24	Bearpaw	0.500Inches ± 0.010	0.510 0.490		
25	Bearpaw	0.060Inches ± 0.030	0.090 0.030		
26	Bearpaw	45.0Degrees ± 0.5	45.5 44.5		
27	Bearpaw	0.460Inches ± 0.010	0.470 0.450		
28	Bearpaw	0.650Inches ± 0.010	0.660 0.640		
29	Bearpaw	0.375Inches ± 0.010	0.385 0.365		

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DART AEROSPACE LTD		Work Order:	
Description: Bearpaw		Part Number:	D5377-1
Inspection Dwg: D5377 Rev: A		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	+/-0.030	388	✓		Vernier	
5.00	+/-0.030	5.00	✓		Vernier	
3.93	+/-0.030	3.929	✓		Vernier	
1.38	+/-0.030	1.379	✓		Vernier	
5.50	+/-0.030	5.502	✓		Vernier	
1.72	+/-0.030	1.729	✓		high gage	
2.00	+/-0.030	2.001	✓		Vernier	
15.44	+/-0.030	15.438	✓		high gage	
4.688	+/-0.010	4.689	✓		Vernier	
0.756	+/-0.010	.753	✓		Vernier	
0.700	+/-0.010	.702	✓		Vernier	
24.00	+/-0.030	24.00	✓		tape	
21.34	+/-0.030	21.350	✓		tape	
6.40	+/-0.030	6.40	✓		Vernier	
3.52	+/-0.030	3.512	✓		Vernier	
0.24	+/-0.030	.249	✓		high gage	
R0.250	+/-0.010	R.250 OK	✓		Gabriel	
0.30 x 45°	+/-0.030 x +/-0.5°	.300 x 45°	✓		Vernier	
0.50	+/-0.030	.505	✓		Vernier	
0.74	+/-0.030	.743	✓		Vernier	
0.95	+/-0.030	.952	✓		Vernier	
Ø0.261	+0.006/-0.001	.2608	✓		PingogD	
0.500	+/-0.010	.501	✓		Vernier	
0.06 x 45°	+/-0.030 x +/-0.5°	.065 x 45°	✓		Vernier	
0.460	+/-0.010	.465	✓		Vernier	
Ø0.650	+/-0.010	.6498	✓		Pingog	
0.375	+/-0.010	.383	✓		Vernier	

Measured by:	<i>[Signature]</i>	Checked by:	<i>[Signature]</i>	QC Inspector:	
Date:	20/8/02/13	Date:	18/02/16	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	16.03.30	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>